

(19) World Intellectual Property
Organization
International Bureau



(43) International Publication Date
1 April 2004 (01.04.2004)

PCT

(10) International Publication Number
WO 2004/026497 A1

(51) International Patent Classification⁷:
B22D 11/06, B21B 1/26, 37/00, 37/34

B21B 1/46,

(81) Designated States (*national*): AE, AG, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, BZ, CA, CH, CN, CO, CR, CU, CZ, DE, DK, DM, DZ, EC, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, MZ, NI, NO, NZ, OM, PG, PH, PL, PT, RO, RU, SC, SD, SE, SG, SK, SL, SY, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, YU, ZA, ZM, ZW.

(21) International Application Number:

PCT/IT2003/000523

(22) International Filing Date: 28 August 2003 (28.08.2003)

(25) Filing Language:

English

(26) Publication Language:

English

(30) Priority Data:

MI2002A 001996

19 September 2002 (19.09.2002) IT

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(84) Designated States (*regional*): ARIPO patent (GH, GM, KE, LS, MW, MZ, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HU, IE, IT, LU, MC, NL, PT, RO, SE, SI, SK, TR), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, ML, MR, NE, SN, TD, TG).

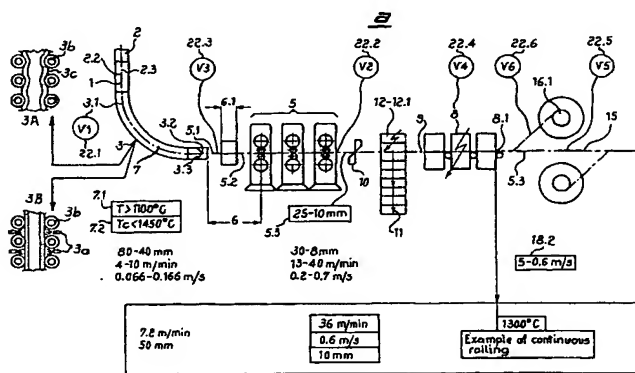
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Published:

— with international search report

[Continued on next page]

(54) Title: PROCESS AND PRODUCTION LINE FOR MANUFACTURING ULTRATHIN HOT ROLLED STRIPS BASED ON THE THIN SLAB TECHNIQUE



(57) Abstract: Process and production line for continuous manufacturing of ultrathin hot rolled steel strip from thin slab obtained through a process of continuous casting comprising a secondary cooling system, a pre-transformation by roughing (5) of the thin slab immediately after the continuous casting, an induction heating (8) to fix temperatures of the intermediate strip chosen between 1000 and 1400°C, a final rolling (18) up to a thickness of the hot finished strip of 0.4 mm at a minimum through not more than 36 six passes while keeping a controlled temperature of the hot rolled strip from the last stand of the finishing rolling mill higher than 750°C. It is also provided a cooling (14), in the time, of the strip (13) between the last stand of the finishing rolling mill and the coiling in view of the specific T.T.T diagram (time-temperature-transformation) for steel quality and strip thickness. A control system of the process is also provided with a master system and six further peripheric sub-systems.

